

5/45

2434

DART AEROSPACE LTD.	Work Order:	24434
Description: Saddle Fitting, Aft (Outboard/Inboard)	Part Number:	D2573/D2574
Drawing: D2573 Rev. D/D2574 Rev. D	Qty:	8
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	PF	05.10.12	8
2	MV	Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B24434	M8	06/01/12	
3	MV	Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B24434	M8	06/01/12	8
4	MV	Fixturing W/O No. 1 Fixturing Inspection last completed by 1	/ N/A	/	
5	MV	Program Batch No. <u>124434</u> Double check by: <u>5</u>	M8	06/01/12	8
6	MV	Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets	SG M8	06/01/12	8
7	MV	Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets	SG M8	06/01/12	8
8	MV	Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets	SG M8	06/01/12	8
9	MV	Machine keyway as per dwg D2573 & D2574	SG M8	06/01/16	8
10	MV	Deburr and remove all machining marks	SG	06/01/16	8
11	MV	Tumble for 20 minutes to remove sharp edges 04.06.21	N/A SG	06/01/20	8
12	QC1	Inspect all dimensions to dimension sheets	SG	06/01/19	8
13	QC7	Second inspection	SG	06.01.20	8
14	FP	Acid etch and alodine as per QSI 005 4.1	SG 06.01.20	06/01/21	8
15	FP	Powder Coat High Gloss White (4.3.5.1) per QSI 005 4.3	SG	06.01.31	8
16	QC3	Inspect Powder Coat	SG	06/01/31	8
17	ST	Identify and Stock.	SG	06/01/31	8
18	AC	Cost / Part	SG	06.02.01	8
19	DC	Close W/O Inspection Level 21	SG	06/02/01	8

Rev	Date	Change	Revised By	Approved
D	99.09.09	Added inspection level, Qty column	EC	
E	00.07.04	Removed P/O for powder coat, drawing change rev. C	EC	
F	00.07.20	Removed inspection level 7	EC	
G	01.04.27	Added D6101-007 & step 8	EC	
H	02.10.02	Re-format; Change to Dwg Rev. D & incorporated D2574	KJ RF	RF

RELEASED
02/10/15 RF